

Work Order ID 52724

October 9, 2009 11:31:40 AM



Page 1

Item ID: D3930-1

Accept



Setup Start



Revision ID: A

Item Name: Clip

Stop



Start Date: 10/09/09 Start Qty: 20.00



Cust Item ID:

Required Date: 10/14/09 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3930

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

7M-L 09/10/14

23X

13 9-10-13

PB 7

23

13 9-10-13

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3930-1 ^{D206-781} PAR #: _____ Fault Category: Small Gas W.J. NCR: (Yes) No DQA: [Signature] Date: 05-10-20
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: [Signature] Date: 09-10-20

NCR: <u>52724</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/10/19	#100	Found qty +1 part that is measin 1.950". should be 2.00". Part made Durain water jet cutting outside pop/ly. part shift lead. R.C. process	<u>[Signature]</u>	Scrap and destroy no replace extras were made	<u>B</u> 9-10-14	6/1/21/20 <u>S</u>	<u>[Signature]</u>	<u>S</u> 07/10/14

NOTE: Date & initial all entries

Work Order ID 52724

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Item Name: Clip

Start Date: 10/09/09 Start Qty: 20.00

Required Date: 10/14/09 Req'd Qty: 20.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

Memo
1- Bend as per dwg D3930

0.00



Brake NC

Brake NC

0.00

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



27 8021014

8021015

27 8021015

counted
122

81

22

counted
122

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52724

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Page 3

Item ID: D3930-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Clip

Start Date: 10/09/09 Start Qty: 20.00



Cust Item ID:

Required Date: 10/14/09 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location: 39B

0.00



Packaging

Memo

0.00

Packaging

9/10/16

sf

234

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/19

MF 09-10-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October 9, 2009 11:31:39 AM

Page 1

Work Order ID: 52724

Parent Item: D3930-1RevA

Parent Item Name: Clip

Comments:

Start Date: 10/09/09

Required Date: 10/14/09

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	48.5234	0.8021			



304/316 .040 Sheet



B9-10-13

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

48.52343684

110076

2.37053684

112567

46.1529

110076

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

C

C

B

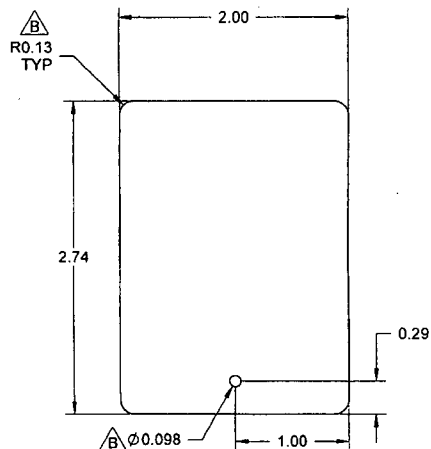
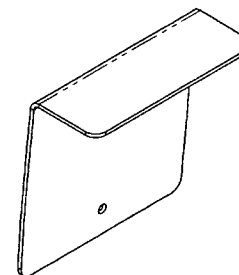
B

A

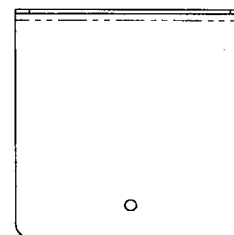
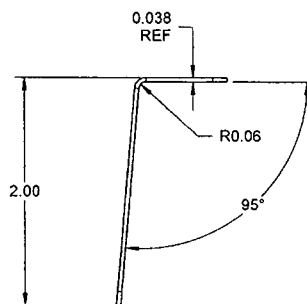
A



WLO
52724



D3930-1F FLAT PATTERN ①



D3930-1 CLIP
(MAKE FROM D3930-1F)

RELEASED
09/06/08 JHP

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
20 GAUGE (0.038 THICK)
REF DART SPEC M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3930-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs

B	R0.13 WAS R0.06 (ZN C8-1); ADD Ø0.098 HOLE TO IMPROVE INSTALLATION (ZN B8-1)	PH	09.05.22
A	NEW ISSUE	PH	09.04.06
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.		D3930	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		CLIP	NTS
DATE	09.05.22	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

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